

Work Order ID 80031

Thursday, February 09, 2012 9:05:05 AM

80031

Page 1

Item ID: D4001-1

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Fitting

Stop ***NS2***

Start Date: 2/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *CMF*

Date: *12-02-09* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4001 | A | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Bandsaw | | | | | | | | | |
| Jeaspa Bandsaw | Memo cut blank 4.200" long | 0.00 | | <i>JK 12-02-14</i> | | | | | <i>(6)</i> |
| 110 | | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| HAAS 1 | | | | | | | | | |
| HAAS CNC vertical machine #1 | Memo MILL AS PER DWG AND FOLIO FA912 FOLIO REV: <i>AA</i> DWG REV: <i>A</i> | 0.00 | | <i>JK 12-02-15</i> | | | | | <i>(6)</i> |
| | DEBURR | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 80031

Thursday, February 09, 2012 9:05:05 AM

80031

Page 2

Item ID: D4001-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fitting

Stop

NS2

Start Date: 2/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 12-02-15

120

QC

Memo

0.00

Quality Control

6 0

130

QC8- Inspect parts - second check

0.00

out 12/02/15

130

QC

Memo

0.00

Quality Control

6 0

140

Identify as per dwg & Stock Location: *WA*

0.00

SL 12-02-16

140

Packaging

Memo

0.00

Packaging

6 0

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 80031***80031***

Page 3

Thursday, February 09, 2012 9:05:05 AM

Item ID: D4001-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fitting

Stop ***NS2***

Start Date: 2/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00


150

QC

Memo

0.00

Quality Control

 M.L. J 12/02/16R12-0216
(6)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, February 09, 2012 9:05:05 AM

Page 1

Work Order ID: 80031

Parent Item: D4001-1

Parent Item Name: Fitting

Start Date: 2/10/2012

Required Date: 2/24/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPPP REV:A NEW ISSUE 10-02-22 JLM VERIFIED BY:EC IPP rev B 10.05.13 ecn10-562 EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.000X04.000 6061-T6 Bar 1.00 x 4.00 | | Purchased | No | | | 100 | f | 74.0828 | 0.3501 | 2.2111579 | | | |

Location

Loc Qty

Loc Code

MAT004

24

116808

0.787

118400

15.003

119346

12.504

119513

9.7888

120243

12

120603

24

SL 12-02-14

2.22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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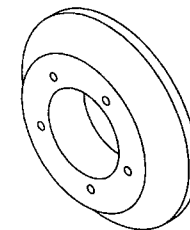
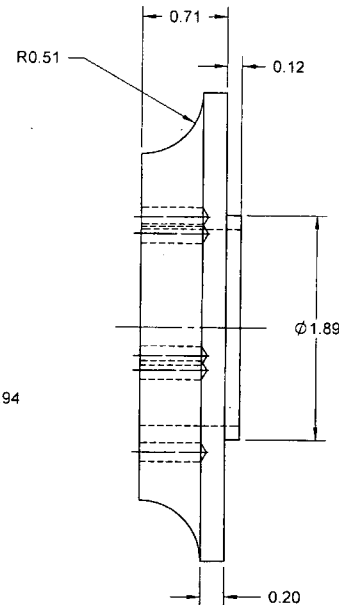
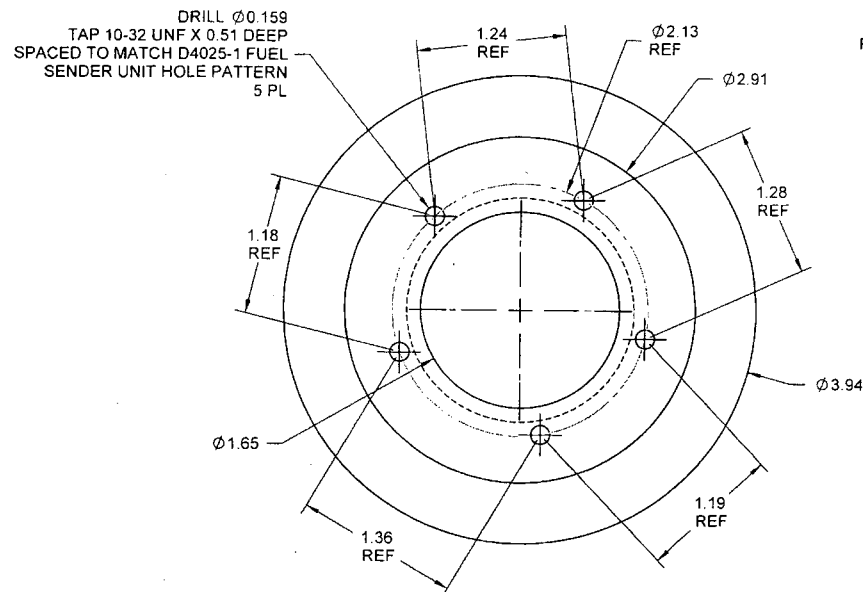
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NOTE: Date & initial all entries

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|-------------------------------|--------------------------------------|
| D4001-1 | JCA-M47-1-08 |



#80031

D4001-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

RELEASED
2010-05-05
W

| REV. | NEW ISSUE | DESCRIPTION | BY | DATE |
|------------|-----------|-------------|----|------|
| DESIGN | | | | |
| DRAWN | | | | |
| CHECKED | | | | |
| MFG. APPR. | | | | |
| APPROVED | | | | |
| DE APPR. | | | | |
| DATE | 10.02.05 | | | |

| | |
|--|--------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. A |
| DRAWING NO. D4001 | SHEET 1 OF 2 |
| TITLE FITTING | SCALE NTS |
| COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

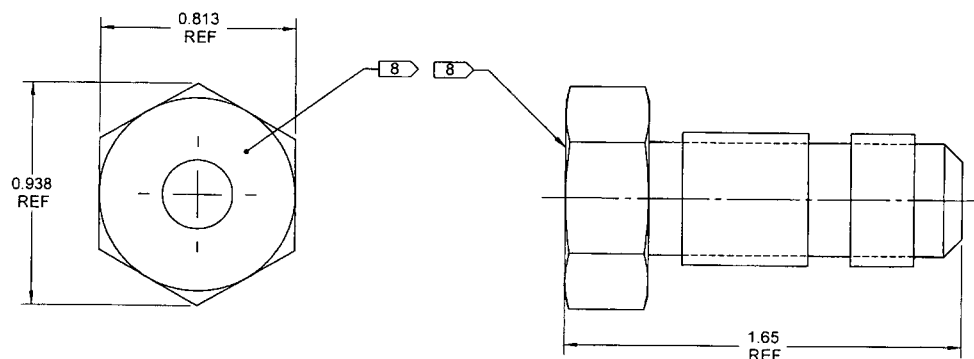
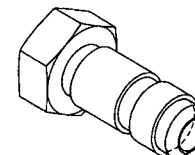
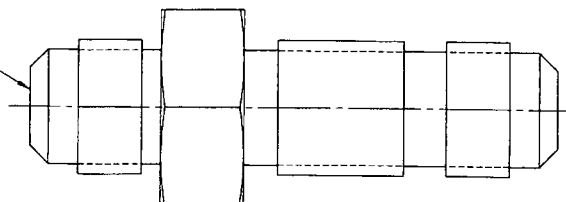
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NOTE: Date & initial all entries

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|-------------------------------|--------------------------------------|
| D4001-3 | JCA-M47-2-28 (AN832-6D-JCA) |

AN832-6D
BEFORE MODIFICATION
REF



D4001-3 FITTING

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM AN832-6D
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) BRUSH ALODINE MACHINED SURFACE

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4001 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FITTING | NTS |
| DATE | 10.02.05 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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